Tuesday, 23/12/2008 3:30:47 PM

User:

Julie Dawson

## **Process Sheet**

Customer Job Number : CU-DAR001 Dart Helicopters Services

: 44321

**Estimate Number** 

: 11172

Prsht Rev.

First Issue

Written By

Previous Run

P.O. Number

: 23/12/2008 This Issue

: NC

: //

: 44157

Type

S.O. No. :

: MACHINED PARTS

**Part Number** 

Drawing Name

: D22827 . D2282 REV E

: E

: TUBE

**Drawing Number Project Number** 

: N/A

**Drawing Revision** 

Material **Due Date** 

: 20/01/2009

Qty:

100 Um:

Each

Checked & Approved By

Comment

: Est Rev:A

08-12-21 Removed from 9 Digit

05-12-02 JLM

Additional Product

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

M304TR0675W091 1.0

304 RD Tube .675 x .091W



Comment: Qty.:

0.0699 f(s)/Unit Total: 6.9930 f(s)

Material: T304/T316 3/8 Schedule 40, Seamless, Ø0.675" OD, 0.091" wall thickness

(M304TR0.675W.091)

Batch 109 364

08/12/29

2.0

HARDINGE CNC LATHE SMALL

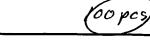


Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Dwg D2282 and Folio FA190

2-Deburr

J-F-/ # 09/17/29
INSPECT PARTS AS THEY COME OFF MACHINE



3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK



PACKAGING RESOURCE #1



5.0

PACKAGING 1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:



Dart A	Aeros	pace	Ltd
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		WORK ORDER C	WORK ORDER CHANGES						
E	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
			<u> </u>						
					i				

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
	T	Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng			Section C	Chief Eng	QC Inspector		
		•						:		

NOTE: Date & initial all entries

Date: User:

Tuesday, 23/12/2008 3:30:47 PM

Julie Dawson

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 44321

Part Number: D22827

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(600)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-31

Dart Ae	rospa	ce Ltd
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W/O:			WORK ORDER	CHANGE\$					
DATE	STEP	PROG	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	):	PAR #:	Fault Category:	NC	R: Yes	No <b>DQ</b>	A:	Date:	
	R	esolution:	_ Disposition:	Q <i>A</i>	: N/C (	Closed:		Date:	

NCR:		,	WORK ORDE	ER NON-CONFORMANC	E (NCR)			
		Description of NC		Corrective Action Section B		Verification	Verification Section C Approval Chief Eng	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			QC Inspector
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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44321
Description: Handle Tube	Part Number:	D2282-7
Inspection Dwg: D2282 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.795	+/-0.010	. 194				
0.493	+/-0.010	£.496				
0.675	+/-0.010	.794 \$.496 .673				
					,	
						<del></del>

Measured by:	4	Audited by:	Prototype Approval:	N/A
Date:	04/12/09	Date: 08/12/29	Date:	N/A

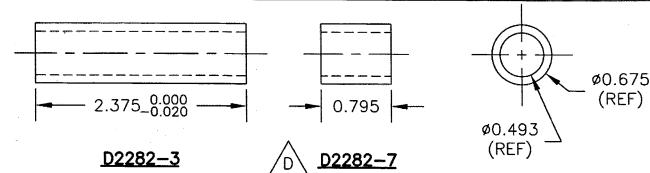
Rev	Date	Change	Revised by	Approved
Α	03.11.11	New Issue P/O D350-615-041	KJ/RF	
_B	05.04.19	0.795 was 0.750	KJ/JLM	
С	06.03.15	Dwg Rev update	KJ/JLM	
D	07.07.17	Dimensions added per Dwg Rev. E	KJ/JLM 🚜	B

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DESIG	BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHEC	(ED .: O	APPROMED_	DRAWING NO.	REV. E		
	ar ar	1000	D2282 SHEET	1 OF 2		
DATE			TITLE	SCALE		
05.0	06.07	· · · · · · · · · · · · · · · · · · ·	HANDLE TUBES	1:1		
Α		94.10.14	NEW ISSUE			
В		95.03.23	RE-DESIGN			
С		97.10.20	CORRECTED NUMBERING SCHEME			
		05.07.40	050501011 00000 5 0 705 11110 0			



Α	94.10.14	NEW ISSUE
В	95.03.23	RE-DESIGN
С	97.10.20	CORRECTED NUMBERING SCHEME
D	05.03.16	REDESIGN D2282-5; 0.795 WAS 0.750
Ε	05.06.07	D2282-5 304 SS WAS 303 SS; R0.063 x 0.063 WAS R0.080 x 0.030



## D2282-3/-7 TUBE:

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED R0.063 x 0.063 DEEP 4  $0.090 \times 45^{\circ}$ 0.95 -CHAMFER 0.158 Ø0.700 R0.350 -Ø0.386 0.125  $0.080 \times 45^{\circ}$ (REF) **CHAMFER** SHOP COPY RETURN TO **ENGINEERING** UNCONTROLLED COP D2282-5 SUBJECT TO AMENDMENT WITHOUT NOTICE D2282-5 STEM: ₩OŖĶ ORDER

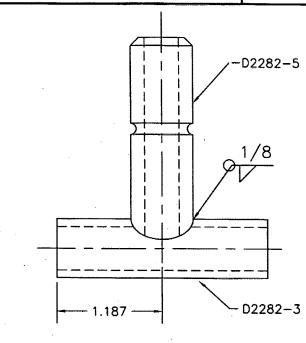
- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750) NO.E
- 2) BREAK ALL UMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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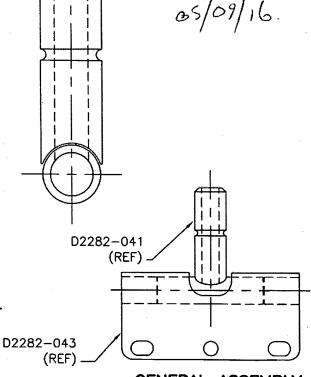
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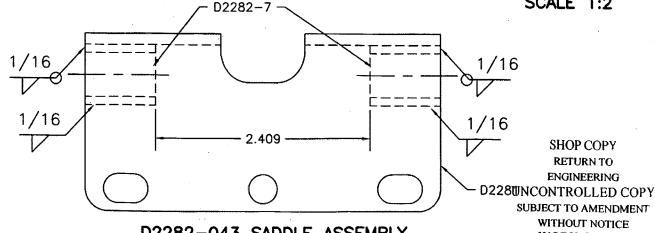
DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
U'	IMP	D2282	SHEET 2 OF 2	
DATE		TITLE	SCALE	
05.06.07		HANDLE TUBES	1-1	



D2282-041 'T' ASSEMBLY WELD ASSEMBLY PER DART QSI 004



## **GENERAL ASSEMBLY** SCALE 1:2



D2282-043 SADDLE ASSEMBLY WELD ASSEMBLY PER DART QSI 004 SUBJECT TO AMENDMENT WITHOUT NOTICE **WORK ORDER** NO. 44321

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